

Date: Friday, 13/02/2009 12:58:01 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ARM ASSEMBLY
<b>Job Number</b> : 45784	
<b>Estimate Number</b> : 13791	
<b>P.O. Number</b> :	<b>Part Number</b> : D2795043
<b>This Issue</b> : 13/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2795 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 1/1 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/02/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09.02.13</u>	
<b>Comment</b> : Est Rev:A New Issue 09-02-11 JLM Verified By:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0500X06000	6061-T6 Bar .500 x 6.00
-----	--------------------	-------------------------



(4)

**Comment:** Qty.: 1.4438 f(s)/Unit Total : 2.8875 f(s)

6061-T6 Bar .500 x 6.00

BATCH: M110 9/2

Mat not entered in computer

H.A

09/02/20

2.0	BAND SAW	BAND SAW
-----	----------	----------



(4)

**Comment:** BAND SAW

Cut blank 16.500" long

H.A

09/02/20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #11- Mill as per Folio FA804 Rev: B & Dwg D2795 Rev: B

2-Deburr per dwg D2795

J.L. H.A 09/02/24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L. H.A 09/02/24

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------

**Comment:** CONVENTIONAL MILLING MACHINE

C'SINK AS PER DWG D2795

J.L. H.A 09/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 13/02/2009 12:58:01 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM ASSEMBLY

Job Number: 45784

Part Number: D2795043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 09/02/24

(4)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 09/02/24

(4)

8.0

D2808

Bushing

8.1



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

BATCH: B41708

EP 09/02/25

(4)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
PRESS BUSHING AS PER DWG D2795

EP 09/02/25

(4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/25

(4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 151

SS 09/02/26

(4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26

(4)

Job Completion



u 09.02.26

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.02.25	<del>7.5</del> 8.0	Chemical conversion coat per QSI005 Permchange		MD/BK 09/02/25	(4)	[Signature] 09.02.25	[Signature] 09.02.25	
		QC3		S 02/02/25		[Signature] 09.02.25	[Signature] 09.02.25	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 45784
<b>Description:</b> arm assembly		<b>Part Number:</b> D2795-3
<b>Inspection Dwg:</b> D2795 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

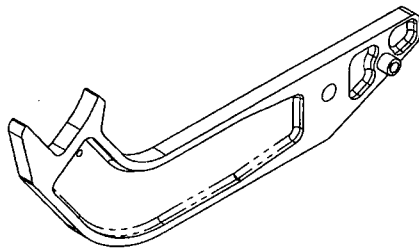
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .010$	.496	✓			
6.501	$\pm .010$	6.502	✓			
4.369	$\pm .010$	4.370	✓			
.800	$\pm .010$	.800	✓			
2.311	$\pm .010$	2.311	✓			
Ø.191	$\pm .005$ $\pm .001$	.193	✓			
4.320	$\pm .010$	4.321	✓			
2.500	$\pm .010$	2.501	✓			
.250	$\pm .010$	.251	✓			
15.506	$\pm .010$	15.504	✓			
13.57	$\pm .030$	13.571	✓			
.250	$\pm .010$	.248	✓			
.250	$\pm .010$	.248	✓			
1.125	$\pm .010$	1.125	✓			
1.00	$\pm .030$	1.001	✓			
2.96	$\pm .030$	2.966	✓			
2.70	$\pm .030$	2.70	✓			
Ø.157	$\pm .010$ $\pm .005$	.158	✓			
1.626	$\pm .010$	1.627	✓			
.440	$\pm .010$	.441	✓			
.575	$\pm .010$	.575	✓			
.625	$\pm .010$	.625	✓			
1.250	$\pm .010$	1.250	✓			

<b>Measured by:</b> J.L.	<b>Audited by:</b> S.D.	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09/02/23	<b>Date:</b> 09/02/24	<b>Date:</b> N/A

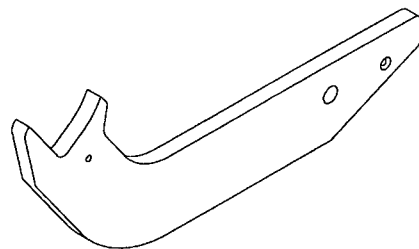
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



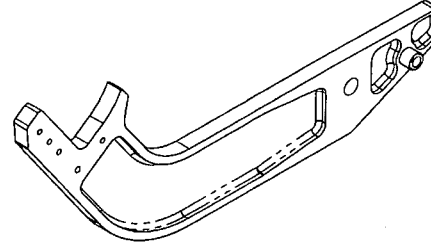
ITEM NO.	QTY. -041	QTY. -042	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X				D2795-041	ARM ASSEMBLY
2		X			D2795-042	ARM ASSEMBLY
3			X		D2795-043	ARM ASSEMBLY
4				X	D2795-044	ARM ASSEMBLY
11	1				D2795-1	ARM
12		1			D2795-2	ARM
13			1		D2795-3	ARM
15				1	D2795-4	ARM
21	1	1	1	1	D2808	SPACER



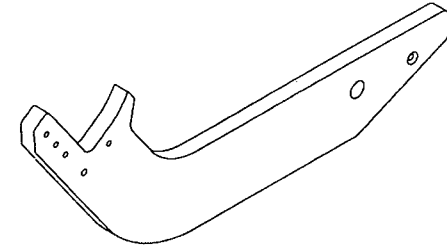
**D2795-041 ARM ASSEMBLY**



**D2795-042 ARM ASSEMBLY**



**D2795-043 ARM ASSEMBLY**

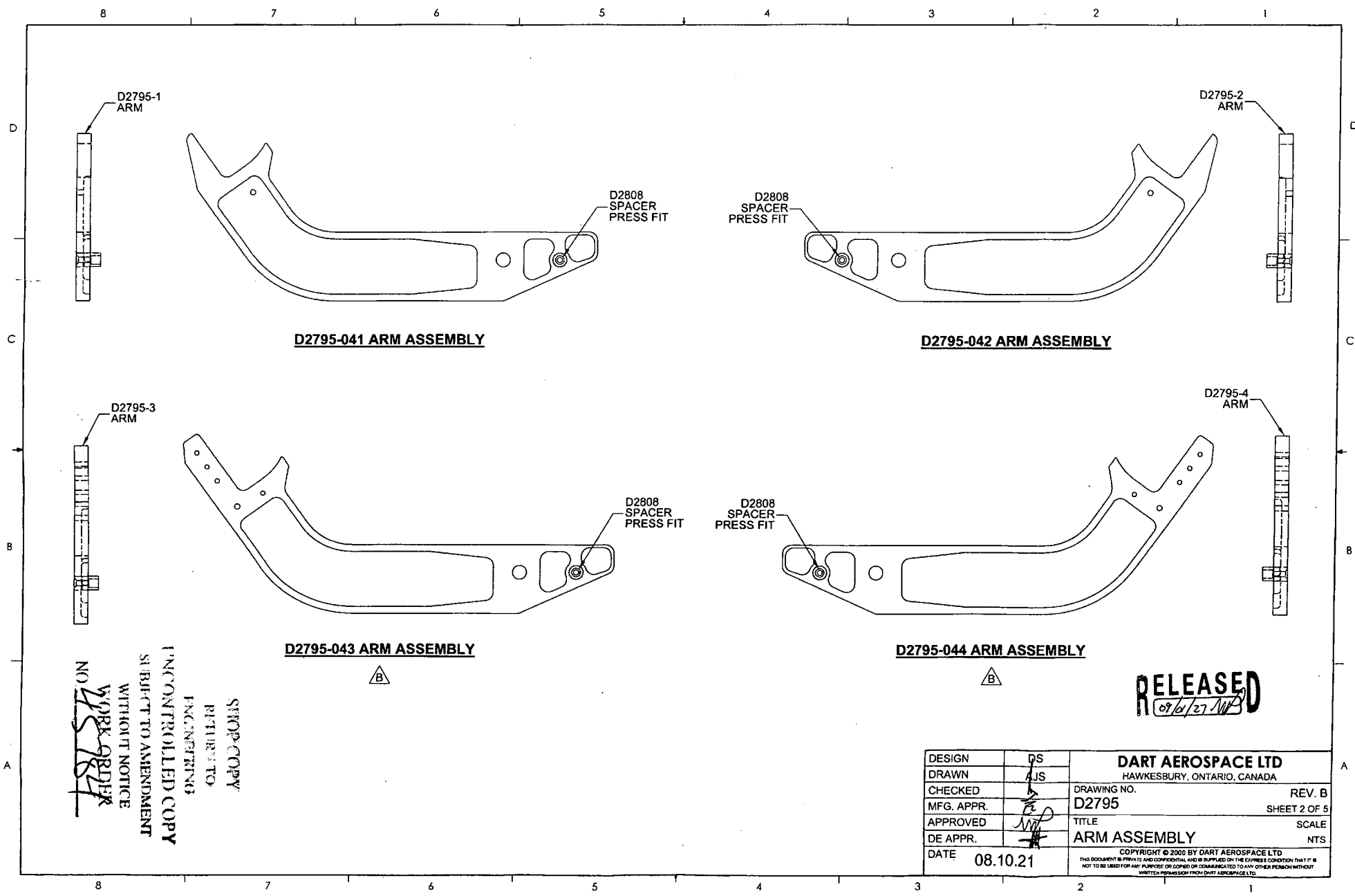


**D2795-044 ARM ASSEMBLY**

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 185184

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2795-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D2795-041/-042 1.22 lbs  
D2795-043/-044 1.29 lbs

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. -1 & -2 PARTS HAD NO PHYSICAL CHANGES BUT WERE REDIMENSIONED. SEE PREVIOUS REV FOR DETAILS. -043, -044 -3 & -4 ADDED. MATERIAL SPECS UPDATED.		AJS	08.10.21
A	NEW ISSUE		DS	00.11.03
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D2795	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		ARM ASSEMBLY	NTS	
DATE	08.10.21		<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D2795-041 ARM ASSEMBLY**

**D2795-042 ARM ASSEMBLY**

**D2795-043 ARM ASSEMBLY**

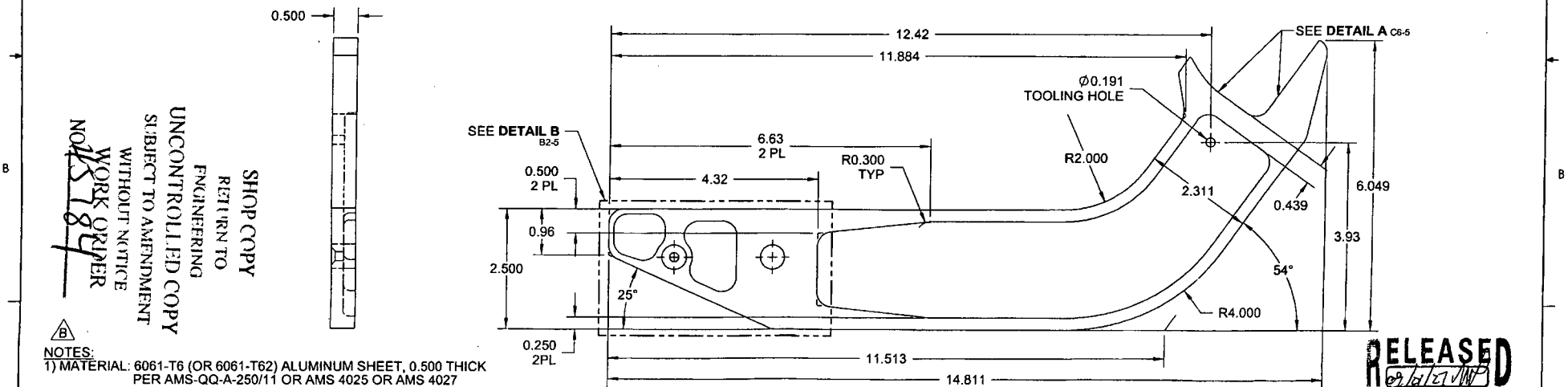
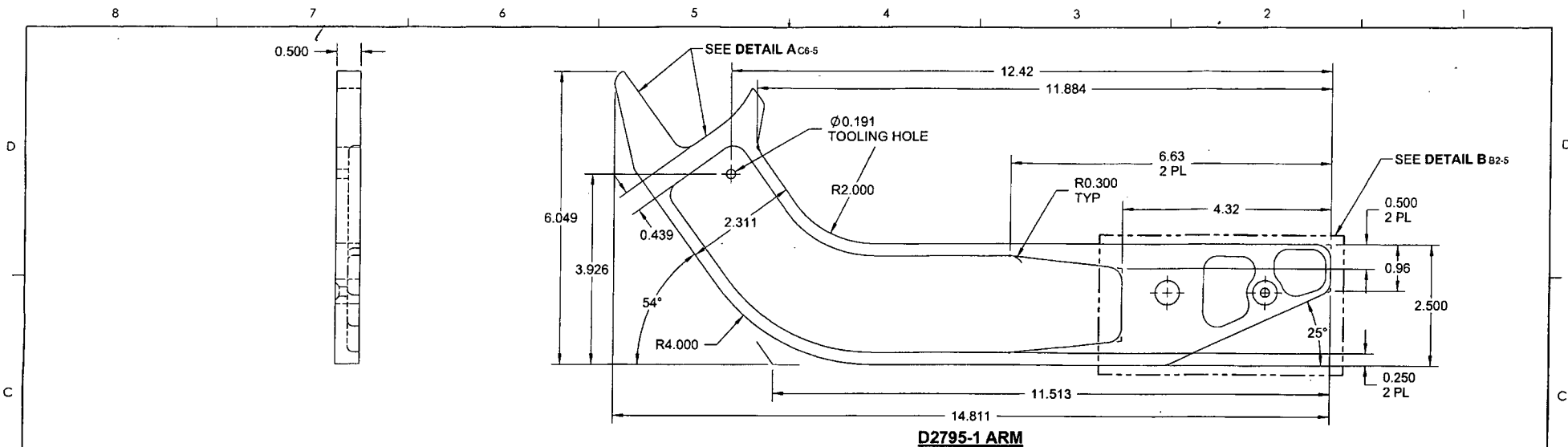
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09/01/27 NW

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D2795</b>	SHEET 2 OF 5
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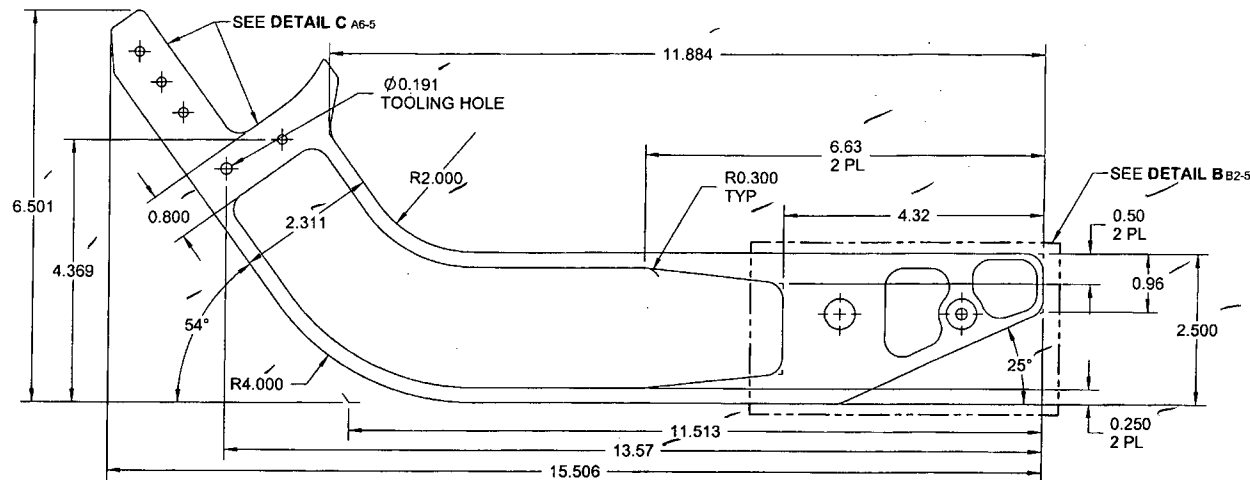




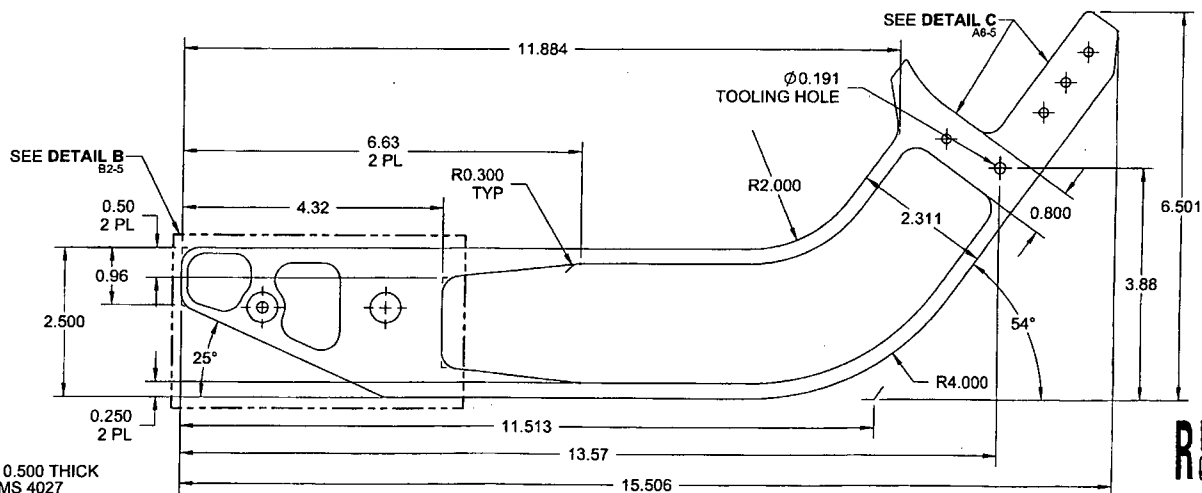
- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.500)
  - OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART SPEC M6061T6B)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: SEE ASSEMBLED WEIGHT

**RELEASED**  
02/12/21

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MFG. APPR.		<b>D2795</b>	SHEET 3 OF 5
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**D2795-3 ARM**



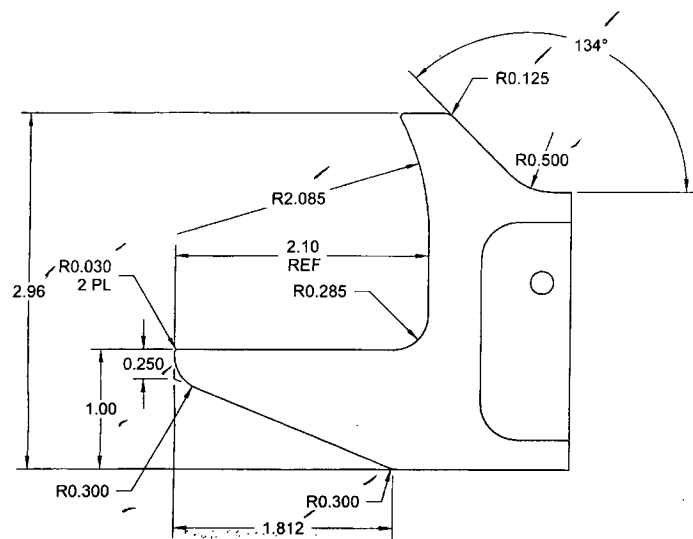
**D2795-4 ARM**

**RELEASED**  
9/16/17 MB

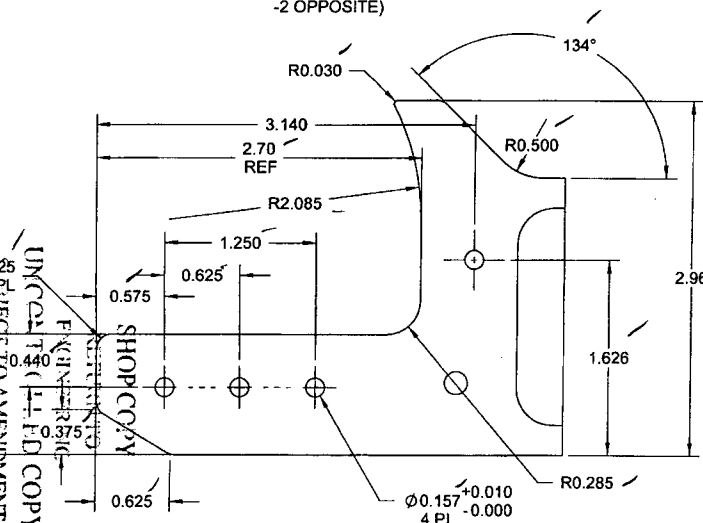
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.500)  
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF DART SPEC M6061T6B)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: SEE ASSEMBLED WEIGHT

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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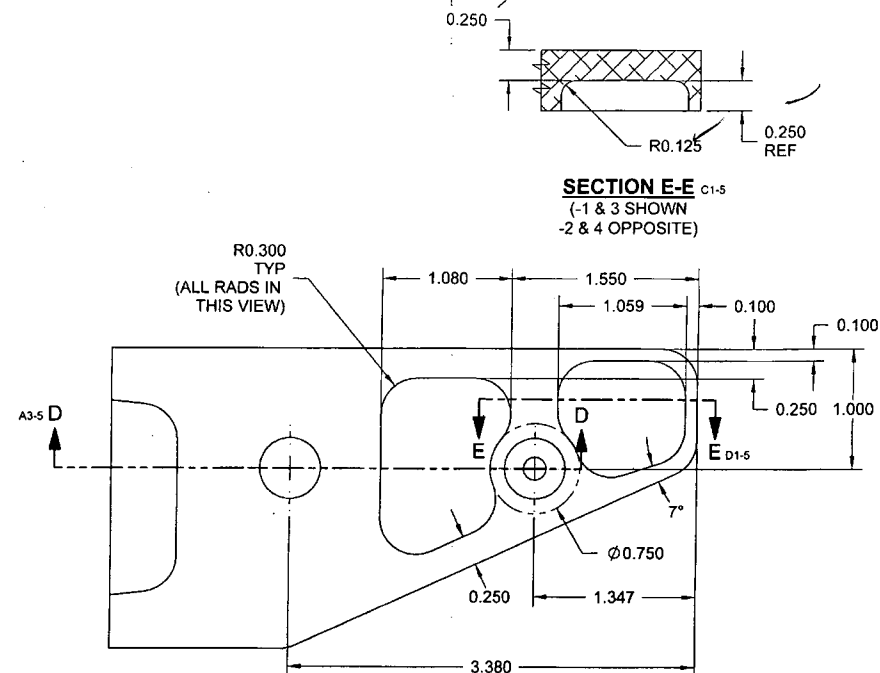
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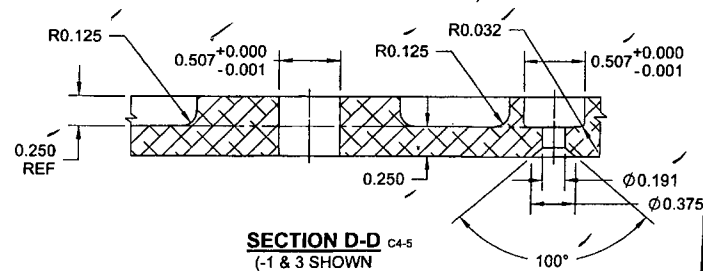
**DETAIL A**  
(-1 SHOWN  
-2 OPPOSITE)



**DETAIL C**  
(-3 SHOWN  
-4 OPPOSITE)



**DETAIL B**  
(-1 & 3 SHOWN  
-2 & 4 OPPOSITE)



**SECTION D-D**  
(-1 & 3 SHOWN  
-2 & 4 OPPOSITE)

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01/01/27

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		<b>D2795</b>	SHEET 5 OF 5
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